

Work Order ID 52886

October 16, 2009 10:34:43 AM



Page 1

Item ID:	D3570-4	Accept		Setup	Start	
Revision ID:	E				Stop	
Item Name:	Bracket					
Start Date:	16/10/2009	Start Qty: 20.00		Cust Item ID:		
Required Date:	02/11/2009	Req'd Qty: 20.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>BT</u>	Date: <u>09-10-16</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<u>Draw Nbr</u>	<u>Revision Nbr</u>								
<u>D3570</u>	<u>E</u>								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
<u>6061</u>	1-Cut as per Dwg D3570								
<u>.125</u>	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	GRAIN DIRECTION AS PER DWG								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

IB 9-11-5

28

IB 9-11-5

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Item ID: D3570-4

Accept



Setup Start



Revision ID: E

Stop



Item Name: Bracket

Start Date: 16/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



2) Sorludos

QC

Memo

0.00

Quality Control

Count
(28)

1

130

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Form as per Dwg D3570 Using DT8945

2-Cut excess material as per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

1 mch 09/11/11

(28X)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

28
counted.

09-11-12

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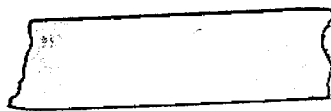


Page 3

Item ID:	D3570-4	Accept		Setup	Start	
Revision ID:	E				Stop	
Item Name:	Bracket					
Start Date:	16/10/2009	Start Qty:	20.00		Cust Item ID:	
Required Date:	02/11/2009	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	22	09/11/12		25x	0		
160 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 3:15pm OVEN TEMPERATURE: 3200F FINISH TIME: 3:45pm	0.00 0.00	⇒	09/11/12		128	0		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		09-11-17		28			



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Page 4



Item ID: D3570-4

Accept



Setup Start



Revision ID: E

Stop



Item Name: Bracket

Start Date: 16/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Identify as per dwg & Stock Location <u>245A</u>	0.00							
Packaging	Memo	0.00							
Packaging									
190 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/11/17 (28) SP

09/11/18

MF 09-11-18

Picklist Print

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Page 1

Work Order ID: 52886

Parent Item: D3570-4RevE

Parent Item Name: Bracket


Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	105.0952	1.8316	3,		
												
6061-T6 .125 Sheet												

13 9-11-5

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	105.0952	
110062	1.85	
111642	19.592	
112476	32	
112567	51.6532	

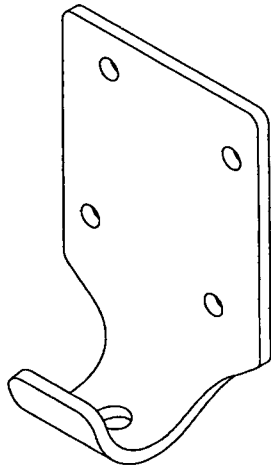
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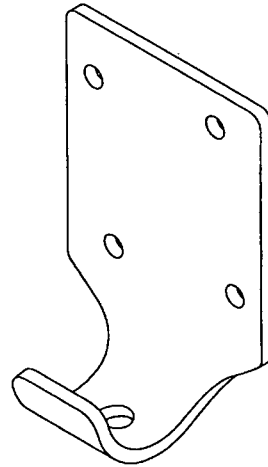
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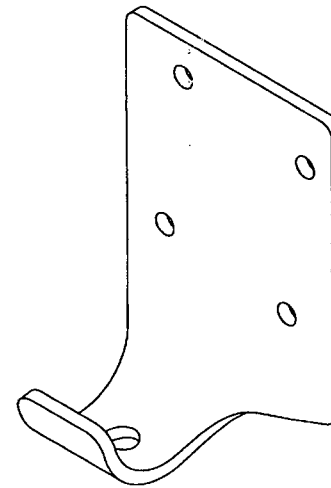
Pl
09-10-16



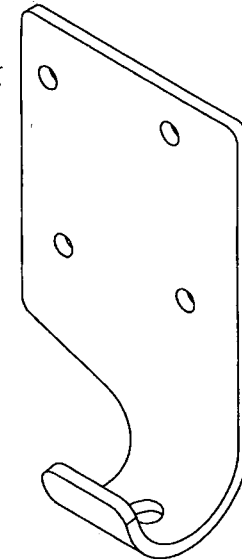
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



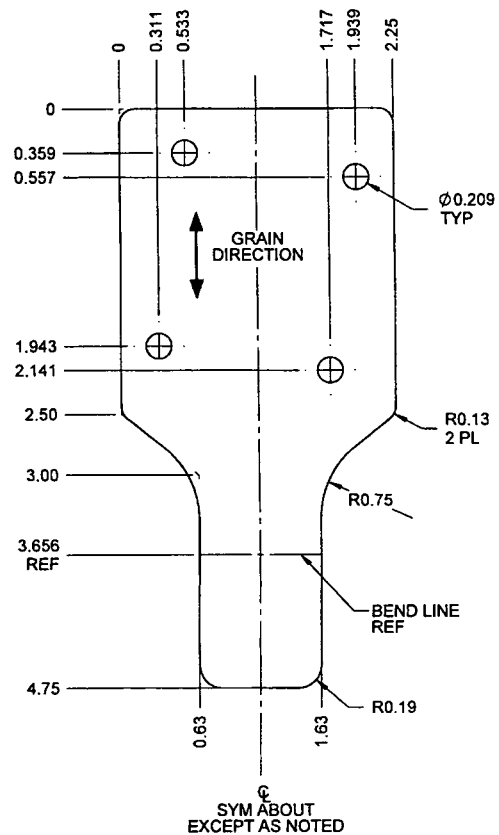
D3570-4 BRACKET

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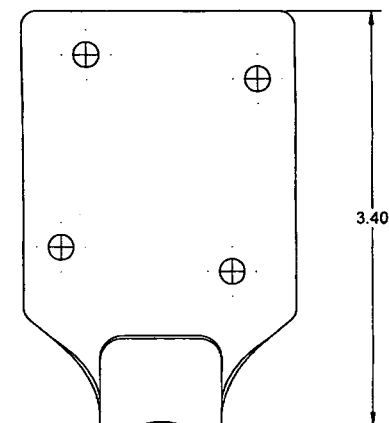
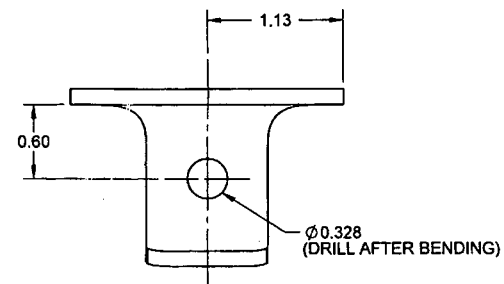
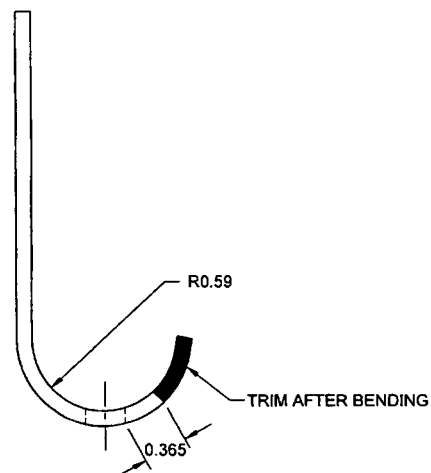
- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

E	SHEET 3 UPDATED D3570-3F FLAT PATTERN, SEE REV D FOR DETAILS. SEE PAR 09-014.	AJS	09.04.22
D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY.	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3570	SHEET 1 OF 5
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DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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D3570-1F FLAT PATTERN

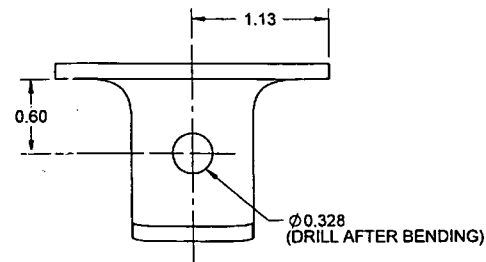
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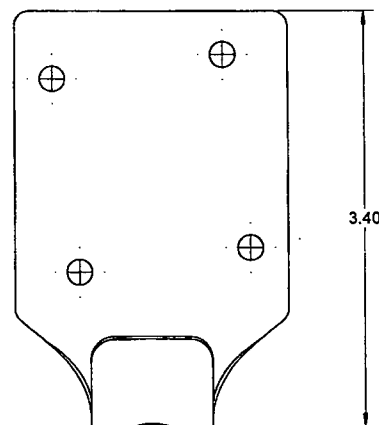
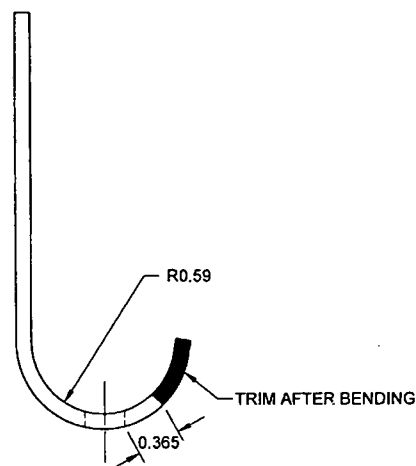
D3570-1 BRACKET
(MAKE FOM D3570-1F)

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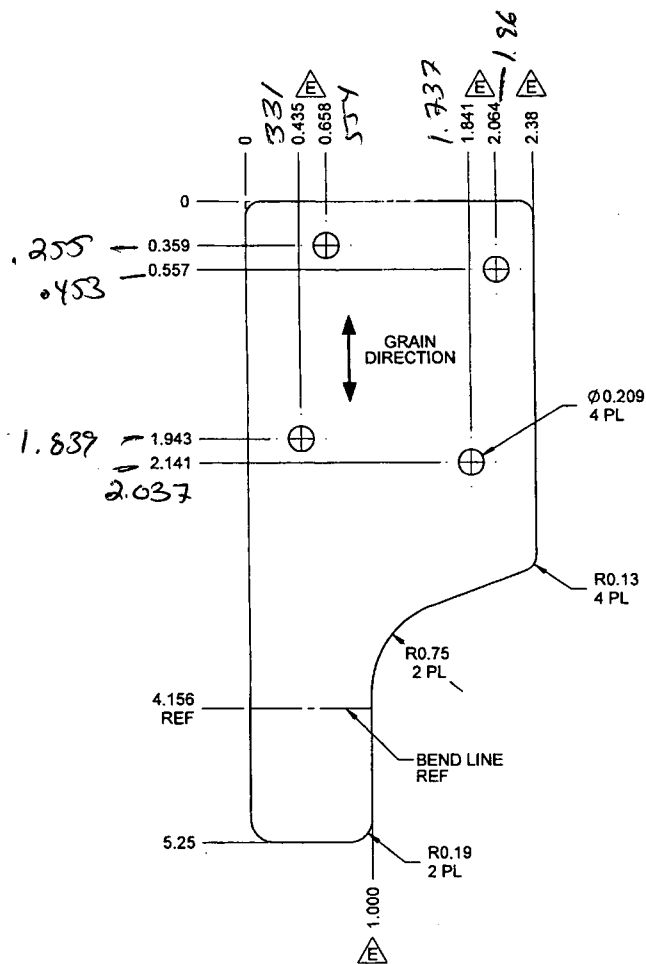
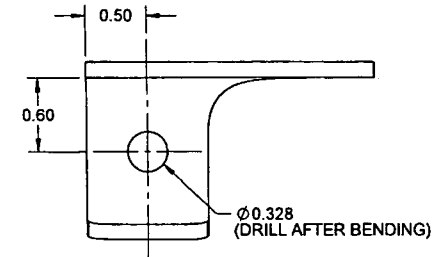


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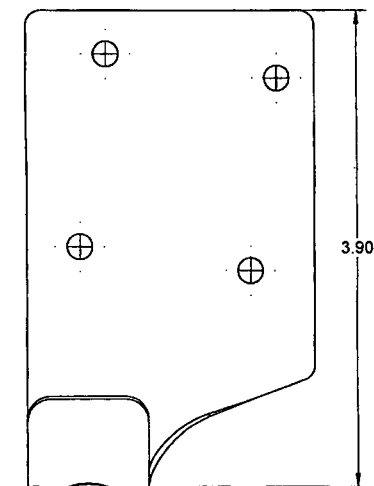
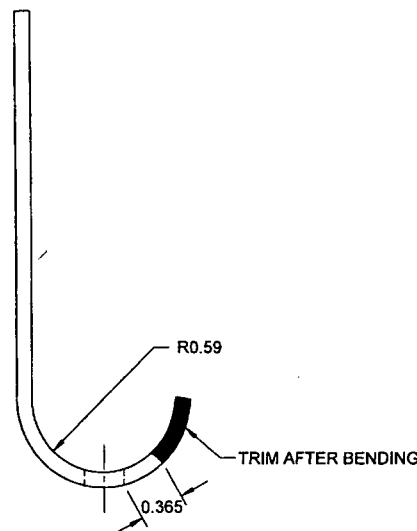
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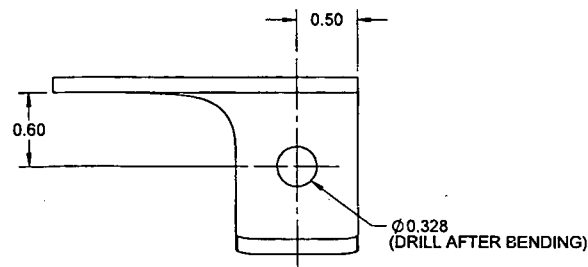
D3570-3F FLAT PATTERN



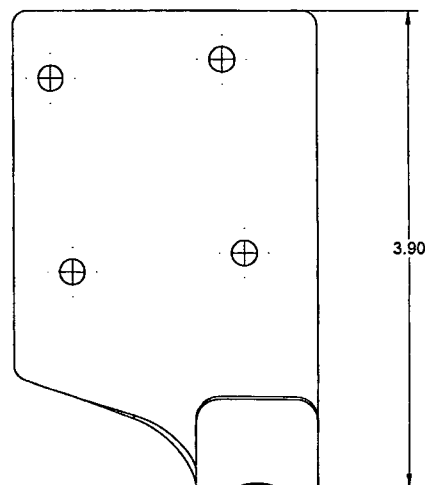
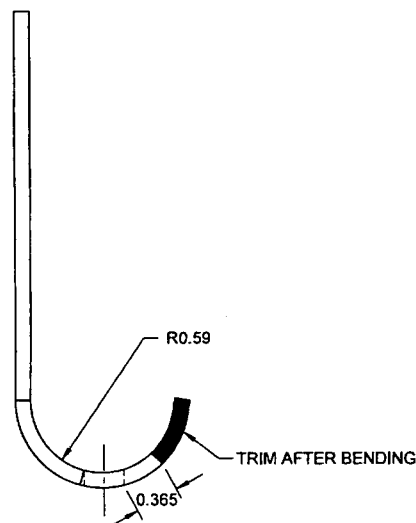
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